

Work Order ID ~~125866~~ -2

Wednesday, October 22, 2014 3:44:23 PM

125866

RUSH

Page 1

Item ID: D4469-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Outer Skin Lower Door

Start Date: 10/22/2014 Start Qty: 3.00

3

Cust Item ID:

Required Date: 10/24/2014 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: MF

Date: 14-10-22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4469	D								

100 FLOW WATER JET 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

③

dx 14/10/23

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.00

Quality Control

③

dx 14/10/23

Work Order ID 125866

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Page 2

Item ID: D4469-1

Revision ID:

Item Name: Outer Skin Lower Door

Start Date: 10/22/2014 Start Qty: 3.00

Required Date: 10/24/2014 Req'd Qty: 3.00

Reference:

Accept

N9000040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(3)38
9-89

OCT 23 2014

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

1 FF**14-01-15**

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

1DAS
41
9-89**15-1-15****GA small fab****bring to Mel first 1X**

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Item ID: D4469-1

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Revision ID:

Item Name: Outer Skin Lower Door

Stop ***NS2***

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Required Date: 10/24/2014 Req'd Qty: 3.00

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							DAS 41 9-89
150									
SprayPaint	Memo	0.00							
Spray Painting	Prime tempo grey as per dwg (note 2) Batch: <u>128927</u>								15-1-15
160	QC14- Inspect Spray Paint	0.00							
160									
QC	Memo	0.00							2B
Quality Control									15-01-22
170	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	w/p 113991								15/01/22

DAS
30
9-89

Work Order ID 125866

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Item ID: D4469-1

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N900040100

Setup Start *NS1*

Revision ID:

Item Name: Outer Skin Lower Door

Stop *NS2*

Start Date: 10/22/2014 Start Qty: 3.00

3

Required Date: 10/24/2014 Req'd Qty: 3.00

3

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLS 1501-30

MS-30

Picklist Print

• Wednesday, October 22, 2014 3:44:20 PM

Page 1

Work Order ID: 125866

Parent Item: D4469-1

Parent Item Name: Outer Skin Lower Door

125866
D4469-1

Start Date: 10/22/2014

Required Date: 10/24/2014

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 11.12.12 new issue DD verf:EC
12.05.17 as per revpb1 DD verf:EC
dwg revB DD VERF:JLM
REV.C DD VERF:JLM
VERF:JLM
IPP REV:B
IPP Rev:C 12.10.09 per
IPP REV:D 13.02.11 PER DWG
IPP REV:E 14.03.27 PER DWG REV.D DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	326.9940	4.463	15			

M6061T6S 032

6061-T6 Sheet 0.032"

★★

Dec 14/10/23

Location

Loc Qty

Loc Code

MAT021

326.994

m129257

23.35

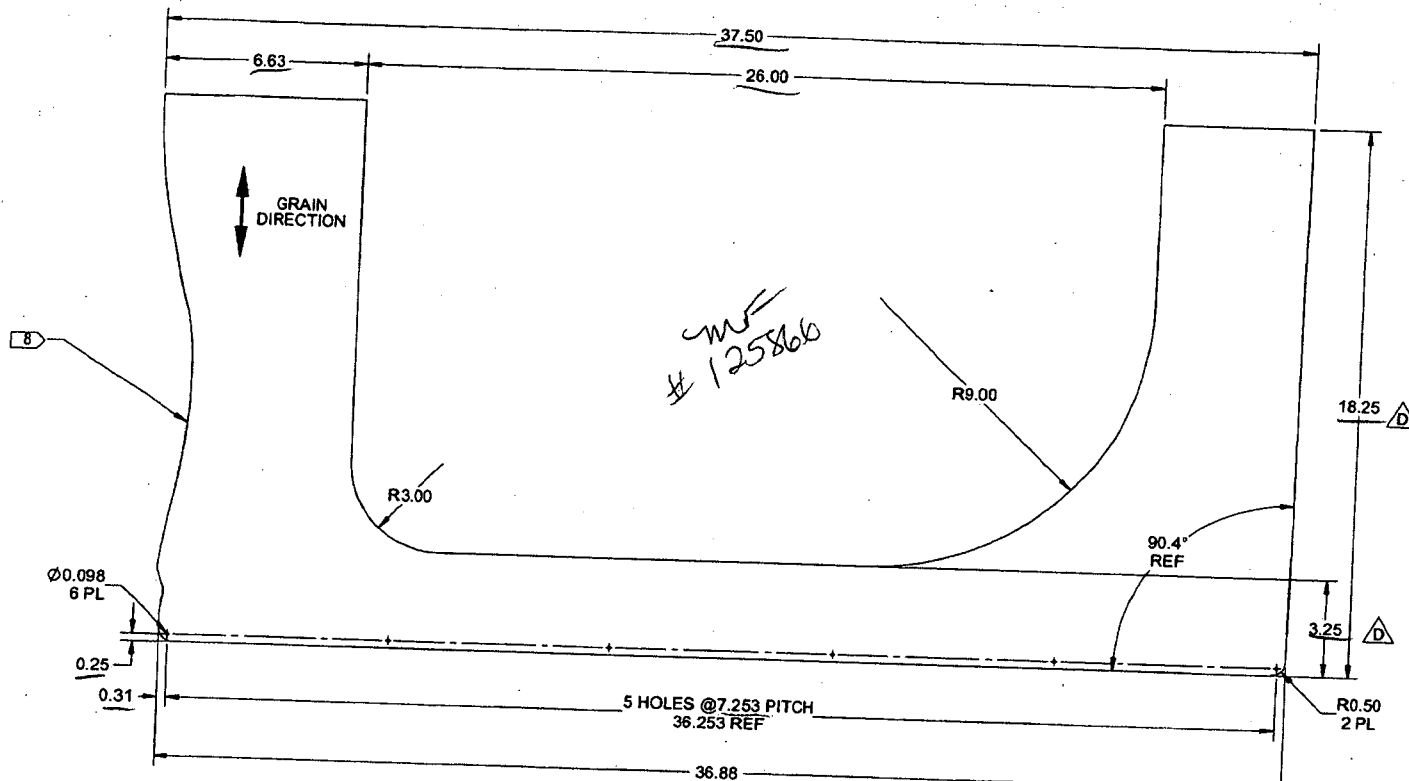
m130387

111.644

m130585

192

20



D4469-1 OUTER SKIN LOWER DOOR

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D4469-1-REVD.DXF"
- 9) FORM PART TO FINAL SHAPE AT NEXT ASSY

RELEASED
2014-03-27

REV.	DESCRIPTION	BY	DATE
D	18.25 DIM WAS 18.00, 3.25 DIM WAS 3.00.	AJS	14.03.24
C	FILLET ADDED TO FWD END, HOLES ADDED FOR SCUFF PLATE.	AJS	12.12.17
B	COMPLETE REDESIGN. SEE REV A FOR DETAILS.	AJS	12.09.10
A	NEW ISSUE	AJS	12.05.10
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4469 OUTER SKIN LOWER DOOR SCALE NTS COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	<i>AR</i>		
MFG. APPR.	<i>AR</i>		
APPROVED	<i>AR</i>		
DE APPR.	<i>AR</i>	DATE 14.03.24	

